

Work Order ID 65938

Thursday, January 27, 2011 1:10:49 PM



Page 1

Item ID: D4032-041

Accept



Setup Start



Revision ID:

Item Name: Short Basket Assembly (350)

Stop



Start Date: 1/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *mf*Date: *11-01-27*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4032

D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Paul 2/4**GBH/02/16**(H)*

Work Order ID 65938

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Thursday, January 27, 2011 1:10:49 PM

Item ID: D4032-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

P P 65597

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control




Thursday, January 27, 2011 1:10:46 PM

Parent Item Name: Short Basket Assembly (350)

Required Date: 2/14/2011

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC IPP Rev:B as per PA3 DD 10.03.10 verified by:EC IPP Rev:C as per RevA DD 10.03.23 verified by:EC IPP Rev:D as per dwg revC DD 10.04.20 verified by:EC IPP Rev:E as per dwg revD DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	11.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST506				11					
				64443				3					
				65094				8					
D2535  Spring		Manufactured	No			100	Each	54.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST504				54					
				58331				14					
				64280				40					
D2537  Bushing		Manufactured	No			100	Each	26.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST504				26					
				64064				26					

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 65938



Parent Item: D4032-041



Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3917-3

Manufactured No

100

Each

18.0000

6

6



Washer

65674

Location

Loc Qty

Loc Code

ST095

17

64589

17

ST096

1

57144

1

D3953-3

Manufactured No

100

Each

7.0000

2

2



Gas Spring Stud, Lid

65622

Location

Loc Qty

Loc Code

ST096

7

65052

7

D3953-7

Manufactured No

100

Each

10.0000

2

2



Spring Spacer

65521

Location

Loc Qty

Loc Code

ST096

9

65053

9

ST103

1

65336

1

65053

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Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 65938

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-9

Manufactured No

100

Each

22.0000

2

2



Gas Spring Washer

Location

Loc Qty

Loc Code

ST096

17

65136

17

ST100

3

64450

3

ST103

2

60008

2

65136

D3953-17

Manufactured No

100

Each

33.0000

2

2



Gas Spring Spacer

Location

Loc Qty

Loc Code

ST097

31

65138

31

ST101

2

57143

1

64021

1

65138

D3953-19

Manufactured No

100

Each

20.0000

1

1



Gas Spring Bracket

Location

Loc Qty

Loc Code

ST

2

59213

2

ST097

18

64810

18

64810

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Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 65938

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-21

Manufactured No

100

Each

9.0000

1

1



Gas Spring Bracket



66110

[Signature]

Location

Loc Qty

Loc Code

ENG

5

56407

5

ST102

4

57145

2

59214

2

D3969-3

Manufactured No

100

Each

18.0000

1

1



Spring (Basket Lid)



[Signature]

Location

Loc Qty

Loc Code

ST272

18

64285

18

D4017-041

Manufactured No

100

Each

0.0000

1

1



Short Basket Base Assembly (350)

B65939 (K)



67285

Ep 5/11/02/16

D4018-041

Manufactured No

100

Each

0.0000

1

1



Short Basket Lid Assembly (350)

B65940 (K)



Ep 5/11/02/16

AN3-14A

Purchased No

100

Each

64.0000

4

4



Bolt



[Signature]

Location

Loc Qty

Loc Code

ST351

64

114941

14

115108

50

115108

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Page 4

W/O:		WORK ORDER CHANGES					
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Work Order ID: 65938

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-16A
Bolt

Purchased

No

100

Each

102.0000

2

2

Location

Loc Qty

Loc Code

ST352

102

114752

52

116419

50

AN4-12
Bolt

Purchased

No

100

Each

26.0000

3

3

Location

Loc Qty

Loc Code

ST357

26

114784

2

116419

24

AN5-17A
Bolt

Purchased

No

100

Each

140.0000

4

4

Location

Loc Qty

Loc Code

ST339

140

116003

40

116590

100

AN310-4
NUT

Purchased

No

100

Each

18.0000

3

3

Location

Loc Qty

Loc Code

ST324

18

116075

18

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 65938

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN310C4

Purchased

No

100

Each

10.0000

2

2



Nut



~ c

Location

Loc Qty

Loc Code

ST349

10

114306

10

MS21042L3

Purchased

No

100

Each

3,053.000

6

6



Nut



m114306
6

~

Location

Loc Qty

Loc Code

ST300

3053

114784

9

115835

544

116391

900

116540

800

116549

800

MS21042L5

Purchased

No

100

Each

1,235.000

4

4



Nut



m115835

~ 64/2/2

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1209

115156

5

115594

500

116104

8

116105

496

116548

200

m115594

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 65938

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-151 Purchased No
Cotter Pin

100 Each 566.0000 3 3

Location Loc Qty Loc Code

ST309 566
17566 566

MS24665-300 Purchased No
Cotter Pin

100 Each 28.0000 2 2

Location Loc Qty Loc Code

ST309 28
110123 28

NAS1149F0432P Purchased No
Washer

100 Each 94.0000 6 6

Location Loc Qty Loc Code

ST275 94
112940 92
114405 1
116169 1

NAS1149C0432R Purchased No
Washer

100 Each 154.0000 2 2

Location Loc Qty Loc Code

ST297 154
114292 36
114742 27
116304 91

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, January 27, 2011 1:10:47 PM

Page 8

Work Order ID: 65938

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 1/28/2011

Required Date: 2/14/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

278.0000

8

8



WASHER

Location

Loc Qty

Loc Code

ST275

278

18057

278

100

Each

150.0000

4

4

NAS1149F0563P

Purchased

No



Washer

Location

Loc Qty

Loc Code

ST298

150

114576

150

18057

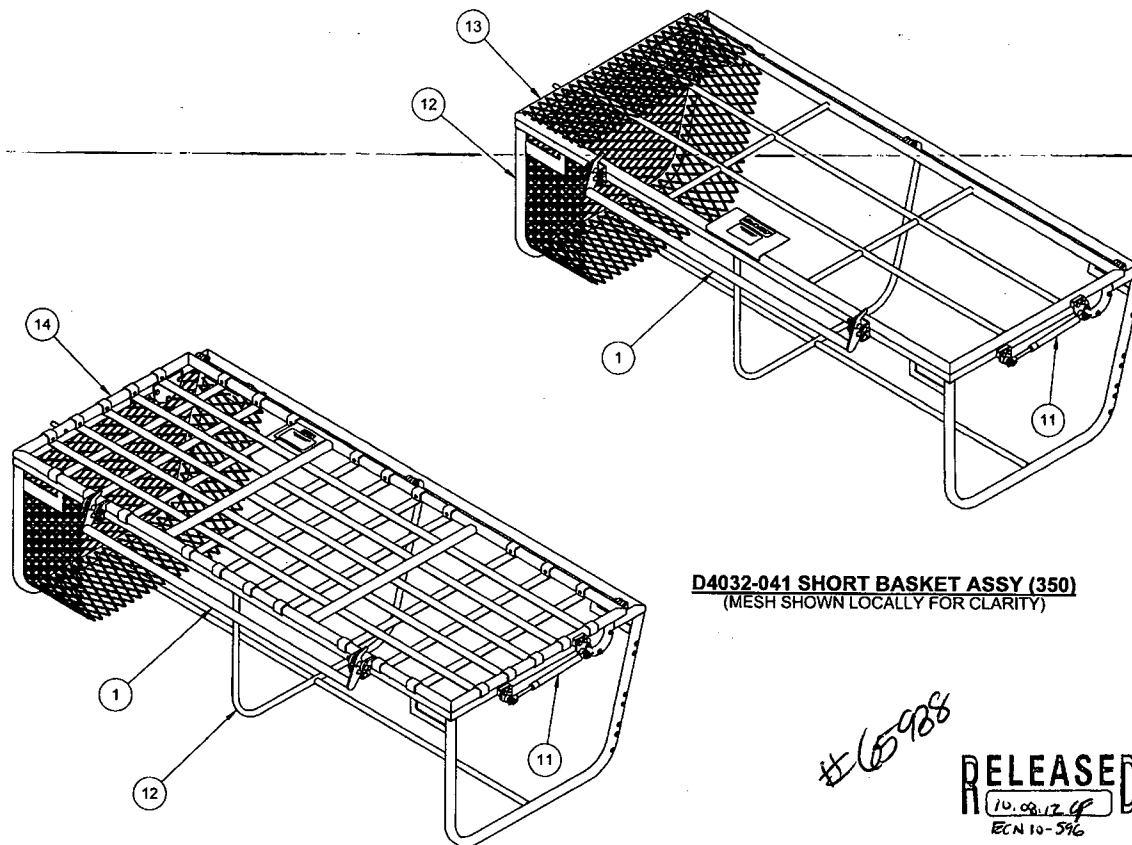
114576

Thursday, January 27, 2011 1:10:47 PM

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Page 8

ITEM	-041 QTY.	-043 QTY.	P/N	DESCRIPTION
	X		D4032-041	SHORT BASKET ASSY (350)
		X	D4032-043	SHORT BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	6	6	D3917-3	WASHER
5	2	2	D3953-3	GAS SPRING STUD, LID
6	2	2	D3953-7	GAS SPRING SPACER
7	2	2	D3953-9	GAS SPRING WASHER
8	2	2	D3953-17	GAS SPRING SPACER
9	1	1	D3953-19	GAS SPRING BRACKET
10	1	1	D3953-21	GAS SPRING BRACKET
11	1	1	D3969-3	SPRING
12	1	1	D4017-041	SHORT BASKET BASE ASSY (350)
13	1		D4018-041	SHORT BASKET LID ASSY (350)
14		1	D4019-041	LIGHT LID SHORT BASKET ASSY
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	2	2	NAS1149C0432R	WASHER
29	8	8	NAS1149F0332P	WASHER
30	4	4	NAS1149F0563P	WASHER



D4032-041 SHORT BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 56-lbs APPROX
-043: 45 lbs APPROX

D	QTY FOR ITEMS #28, #29 & #30 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
C	AN5-21A BOLT WAS AN5-19A BOLT: BOM & (D3-3)	JPH	10.04.06
B	ITEM 15 D4086-232 & 16 D4086-243 REMOVED, ITEM RENUMBERED AS REQD. PLACARDS REMOVED (C6-2); TOP VIEW DETAIL REMOVED (C2-2)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	9	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JES	DRAWING NO.	REV. D
MFG. APPR.	JES	D4032	SHEET 1 OF 3
APPROVED	INP	TITLE	SCALE
DE APPR.	CH	SHORT BASKET ASSY (350) — NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

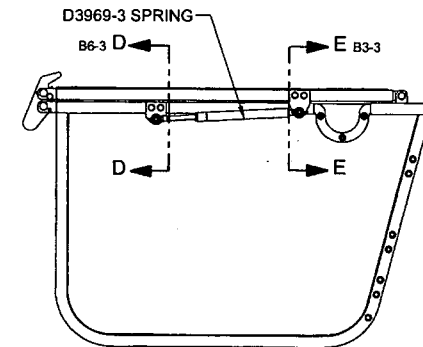
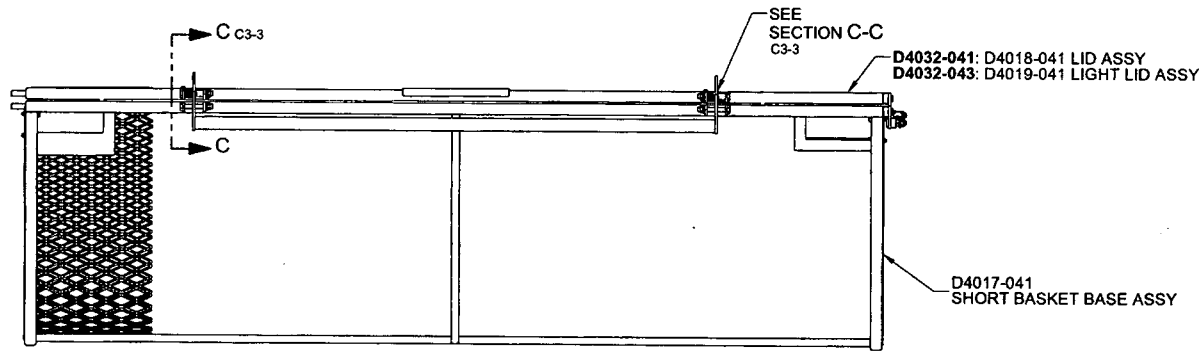
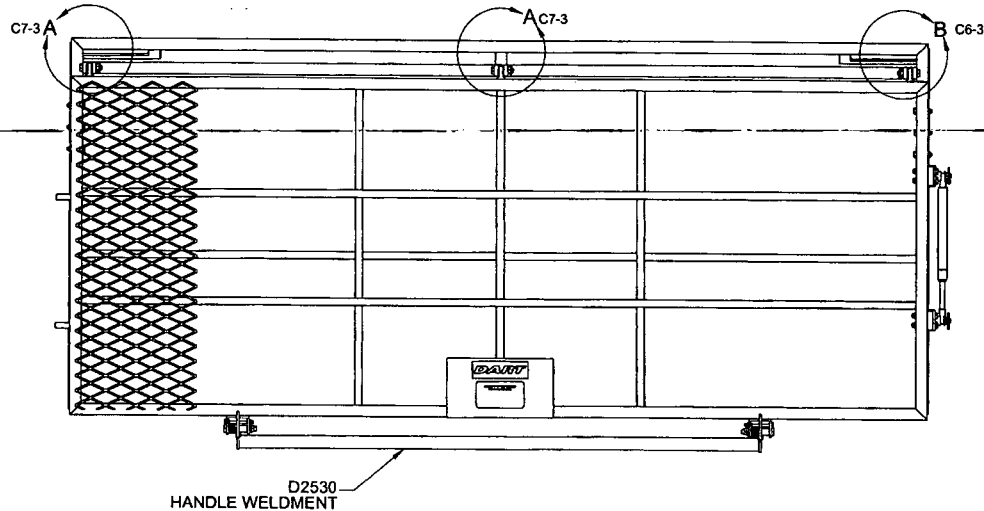
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4032-041 SHORT BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17

DESIGN	AIS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	JFS	D4032	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET ASSY (350)	NTS
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

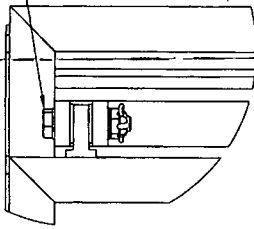
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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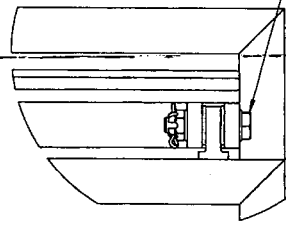
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



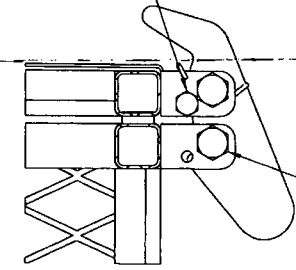
DETAIL A D8-2
D6-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



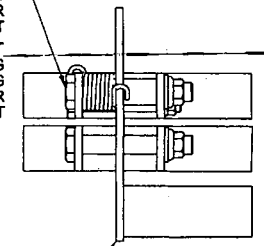
DETAIL B D4-2

D4032-041: AN3-16A BOLT
MS21042L3 NUT
D4032-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B5-2
B7-2

D4032-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4032-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT

D2530 WELDMENT
REF

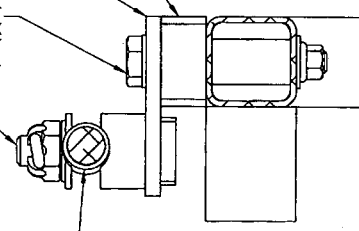
D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2



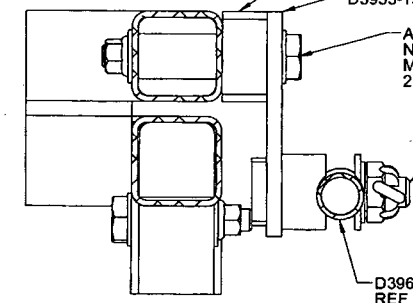
D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2



#65928

RELEASED
10.08.17.0

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JFS	D4032	SHEET 3 OF 3
APPROVED	JFS	TITLE	SCALE
DE APPR.	JFS	SHORT BASKET ASSY (350)	
DATE	10.07.23	NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries